

4130 375

Work Order ID 165352***165352***

Page 1

Monday, August 21, 2017 2:32:45 PM

Item ID: 647.7713 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Strut Thread
Start Date: 8/23/2017 **Start Qty:** 20.00 ***20*** **Cust Item ID:**
Required Date: 8/29/2017 **Req'd Qty:** 20.00 ***20*** **Customer:**
Reference:

AUG 22 2017

Approvals: **Process Plan:** DAS 21 **Date:** AUG 22 2017 **Tooling:** **Date:** **Run Start** ***NR1***
QC: 9-89 **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7700	A2

100

0.19

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

3.54

Hardinge CNC Lathe Small

Machine as per folio FB149

 FOLIO REV: 44
 DWG REV: 42

****NOTE TOL ON THREAD****

CHECK WITH GO/NO GO GAUGE /DO NOT USE THREAD GAUGE

Deburr

21 Ø

DAS
23
9-89

17/9/14

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.20

Quality Control

21 Ø

DAS
23
9-89

17/9/14

Picklist Print

Monday, August 21, 2017 2:32:48 PM

Work Order ID: 165352

165352

Parent Item: 647.7713

647 7713

Parent Item Name: Strut Thread

Start Date: 8/23/2017

Required Date: 8/29/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12-11-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.375		Purchased		No		100	f	12.0000	0.2	4.210526			

M4130NR0 375

4130 steel RD bar .375"

Location

Loc Qty

Loc Code

MAT032

12

m137512

12

4.833

DAS
23
9-88

17/9/14

INSPECTION SHEET

17.09.26

DAS
23

32





APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO. 05397

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED BY T. CROSS

DATE: 05/02/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY: ENGR

MFG

QC

EFF:

CURRENT ORDER

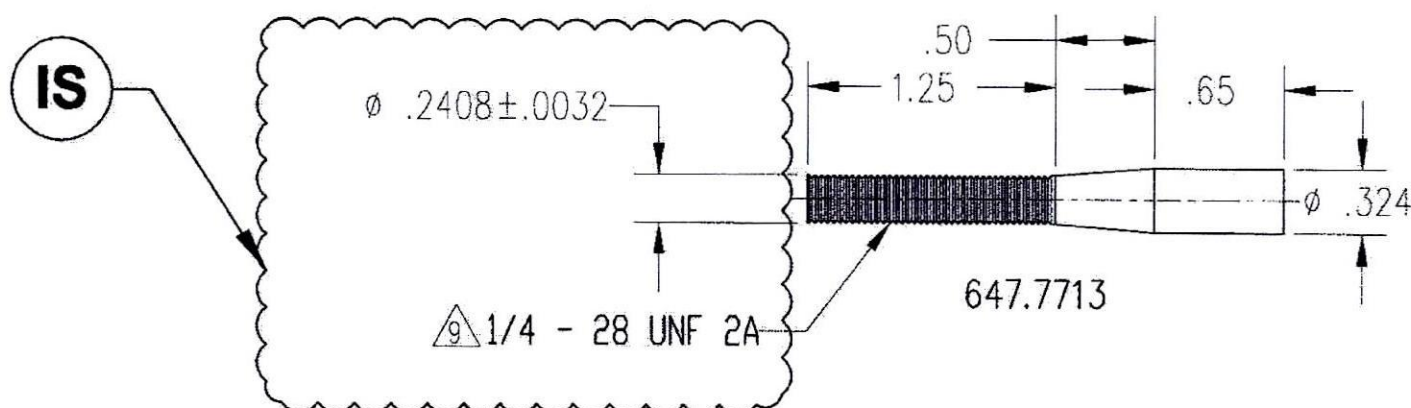
REASON: REVISED DIMENSION

ECR:
16-028

ACTION LIST:
1.

SHEET 2, ZONE D4 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165352 MC5
1708-22



DOCUMENTS EFFECTED:

☐ PATTERN

☐ MDL

☐ INSTALL INSTRU

☐ ICA

☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM				☐ MAJOR ☐ MINOR	☐ YES ☐ NO

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NOTES:

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISIONING		ALC
2	INITIAL RELEASE	11/02/08	P. BRAVO
3	INCORPORATED ECN 04741	11/13/14	P. BRAVO

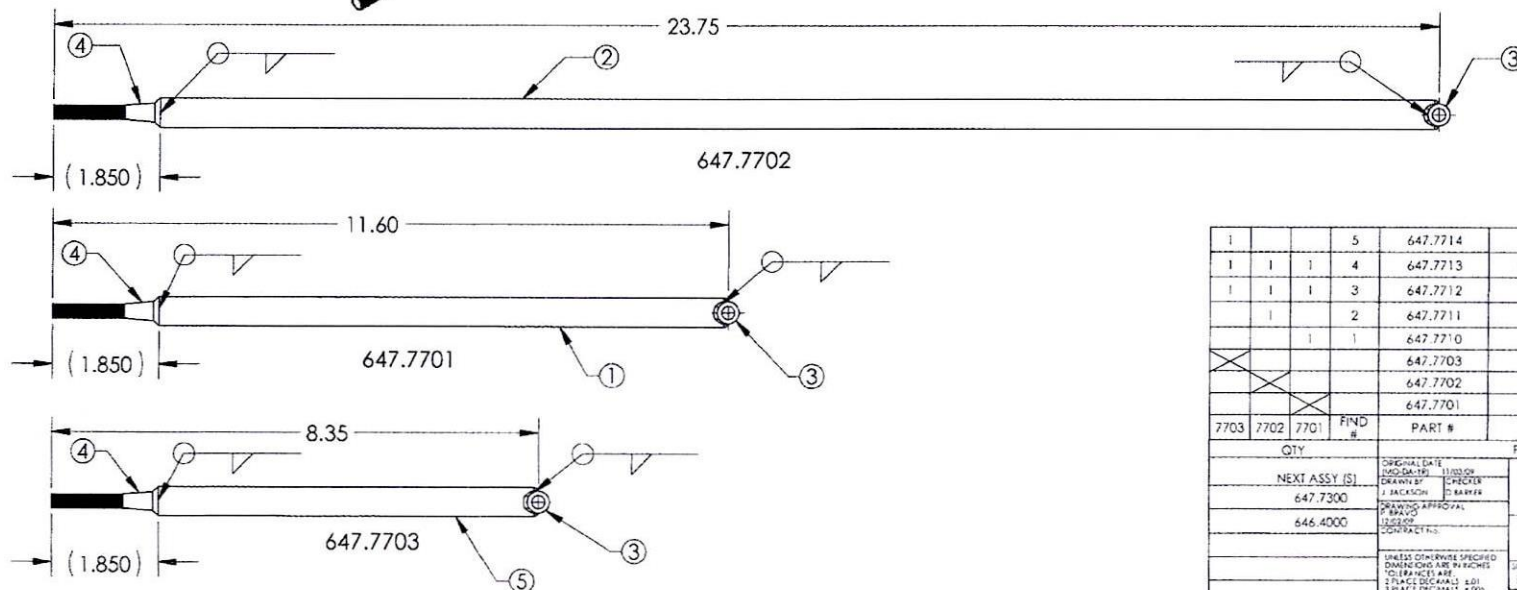
647.7701

647.7703

647.7702

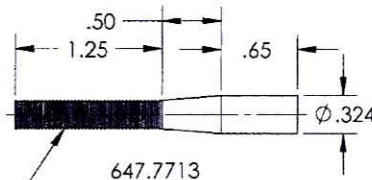
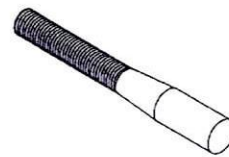
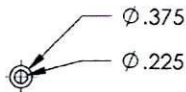
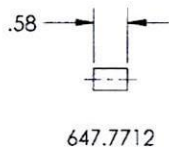
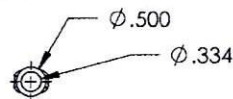
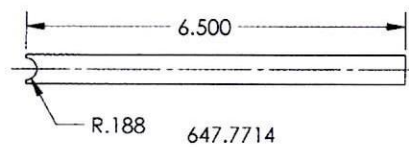
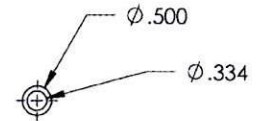
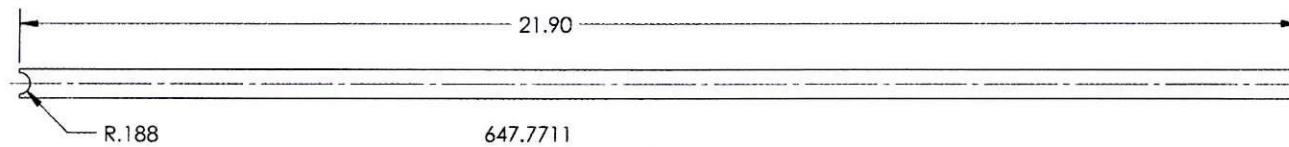
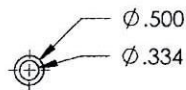
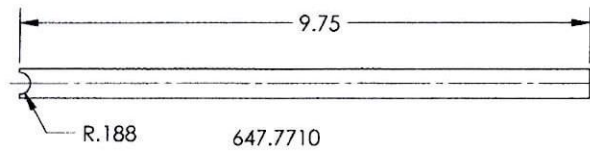
UNINCORPORATED ECN(s)

05110, 05397,



1	2	3	4	5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△	
1	1	1	3	647.7712	STRUT TUBE	△		
	1		2	647.7711	STRUT TUBE	△		
		1	1	647.7710	STRUT TUBE	△		
				647.7703	STRUT ASSY		△△	
				647.7702	STRUT ASSY		△△	
				647.7701	STRUT ASSY		△△	
7703	7702	7701	FIND #	PART #	DESCRIPTION	MATL	SPEC.	
QTY					PARTS LIST			
NEXT ASSY (S)					ORIGINAL DATE 11/02/08			
647.7300					DRAWN BY: C. PROCTOR			
646.4000					1. JACKSON			
					DRAWING APPROVAL: P. BRAVO			
					DESIGN CONTRACT #:			
					UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
					TOLERANCES ARE:			
					2 PLACE DECIMALS: ±.01			
					3 PLACE DECIMALS: ±.005			
					ANGLES: ±.3°			
					APICAL INDUSTRIES			
					2408 TEMPLE HEIGHTS DR.			
					OCEANSIDE, CA. 92056-3512 (760)724-5300			
					STRUT ASSY			
					REV. 3	DATE CODE 07/14/16	DWG. NO. 647.7700	REV. A
					SCALE: NONE			
					SHEET 1 OF 2			

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1/4 - 28 THREAD

ORIGINAL DATE: 11/03/06 MOD DATE: 11/03/06 DRAWN BY: J. JACKSON CHECKED BY: J. JACKSON DRAWING APPROVAL: P. BRAYO CONTRACT NO:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .XX 3 PLACE DECIMALS .XXX ANGLES 1/2°		SGT CAGE CODE: B 07M26 DWG NO: 647.7700 SCALE: NONE	REV: A SHEET: 2 OF 2
		STRUT ASSY	